

Work Order ID 59240

May 28, 2010 2:09:30 PM



Page 1

Item ID: D3095-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 5/27/10 Start Qty: 3.00



Cust Item ID:

Required Date: 6/04/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3095	Rev B

105

0.00



Waterjet

Memo

B
B

0.00

FLOW CNC Waterjet

6061 .050

FB 10-6-2

6

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 10-6-2

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal

46

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Item ID: D3095-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 5/27/10

Start Qty: 3.00



Cust Item ID:

Required Date: 6/04/10

Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

G. 11 10 - 06 - 07 (6)

180

Identify as per dwg & Stock Location: 35

0.00



Packaging

Memo

0.00

Packaging

(X6) JB 10/06/09

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09 JF

MF
10-6-9

Picklist Print

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Page 1

Work Order ID: 59240



Parent Item: D3095-1



Parent Item Name: Angle

Start Date: 5/27/10

Required Date: 6/04/10

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

sf

39.0900

0.17

3



1810-6-2

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT21

39.09

110791

4.5

113216

31.59

17349

3

17349

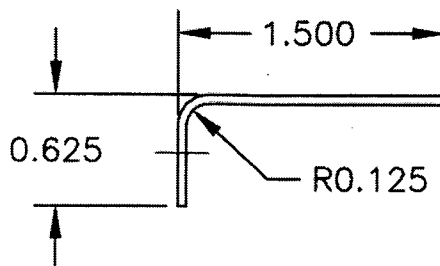
6



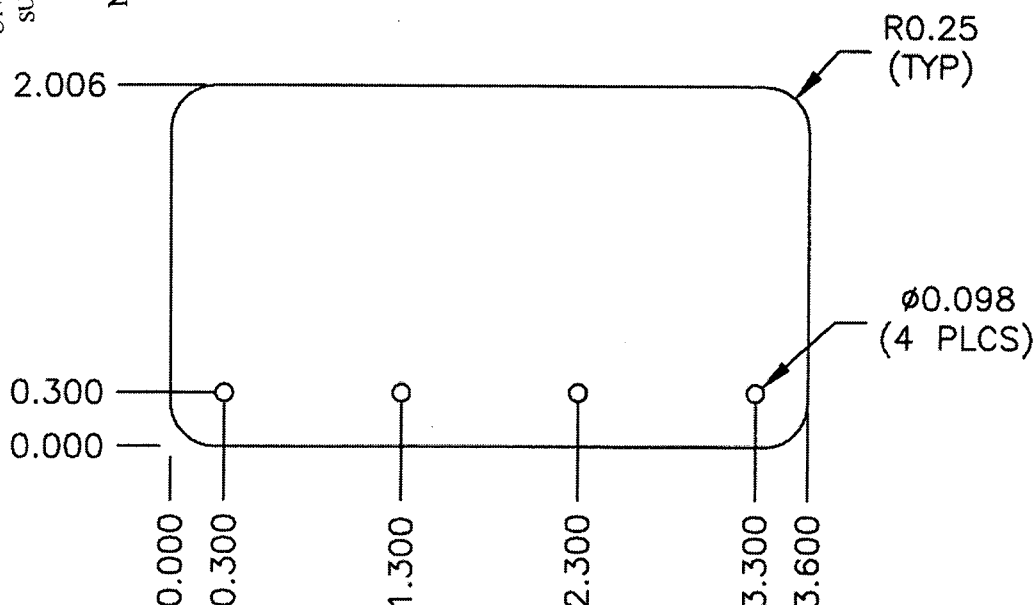
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3095	REV. B SHEET 1 OF 1
DATE 02.06.03		TITLE ANGLE	SCALE 1:1
A	02.03.07	NEW ISSUE	
B	02.06.03	INCREASE WIDTH FROM 1.000 TO 1.500	

RELEASED
02.06.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59240
P110-5-20



D3095-1



D3095-1 FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.050 THICK
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries